

REPRINT

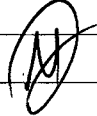
Work Order ID 141295

141295

Page 1

Tuesday, March 29, 2016 10:06:52 AM

Item ID: D4417-011 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Q.R. Step Assembly (206L/407)
Start Date: 3/28/2016 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 3/29/2016 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan:  Date: 3.29 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2690	B2
D4417	B

100 Pick Kit 0.00

MAR 29 2016

100

Packaging Memo 0.00

Packaging

DAS
8
3-29

120 0.00

120

HandFinish Memo 0.01

Hand Finishing

1- ASSEMBLE AS PER DWG
2- USE CBL-1240 AND CBL-460 TO MAKE D2690-6. CUT CBL-1240
CABLE AND CRIMP CBL-460 AS PER DWG D2690

120 16163129

Work Order ID 141295

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Item ID: D4417-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Q.R. Step Assembly (206L/407)

Start Date: 3/28/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/29/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

①

16-03-29

DAS

9

9-89

210

Identify as per dwg & Stock Location: _____ 0.00

210

Packaging

Memo

0.00

Packaging

PPP 142387

DAS

28

9-89

MAR 29 2016

220

QC21- Final Inspection - Work Order Release 0.00

220

QC

Memo

0.00

Quality Control

ML5

MAR 29 2016

①
16-03-29

Picklist Print

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Work Order ID: 141295

141295

Parent Item: D4417-011

D4417-011

Parent Item Name: Q.R. Step Assembly (206L/407)

Start Date: 3/28/2016

Required Date: 3/29/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC IPP
REV:B 11.08.17 PER REV.B. DD VERF:JLM IPP REV:C
11.10.25 replace D2690-6 for CBL-460 & CBL-1240 for assembling purpose
DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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CBL-1240		Purchased	No			120	f	462.0620	0.708	0.708			
CBL-1240													
Cable													

Location Loc Qty Loc Code

GA 462.06196
m132518 462.06196

CBL-460		Purchased	No			120	Each	124.0000	2	2			
CBL-460													
Loop Sleeve													

Location Loc Qty Loc Code

GA 124
m131619 5
m132518 16
m133344 10
m133786 5
m133875 4
m133985 79
m134385 5

D4417-041		Manufactured	No			120	Each	1.0000	1	1			
D4417-041													
Step Assembly													

Location Loc Qty Loc Code

PKG 1
141347 1

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986
0
06

Picklist Print

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Page 2

Work Order ID: 141295

141295

Parent Item: D4417-011

D4417-011

Parent Item Name: Q.R. Step Assembly (206L/407)

Start Date: 3/28/2016

Required Date: 3/29/2016

Start Qty: 1.00

Required Qty: 1.00

D4418-1 Manufactured No

120 Each 2.0000 2 2

D4418-1

Step Lug

DAS

8

9-89

Location

Loc Qty

Loc Code

st535

2

119148

2

D2570 Manufactured No

120 Each 77.0000 4 4

D2570

Bushing

DAS

8

9-89

Location

Loc Qty

Loc Code

FG

12

88781

12

FP001

5

138946

5

ST008

60

138946

60

AN4C16A Purchased No

120 Each 17.0000 2 2

AN4C16A

BOLT

DAS

8

9-89

Location

Loc Qty

Loc Code

ST343

17

m134023

5

m134474

12

AN4C36A Purchased No

120 Each 12.0000 2 2

AN4C36A

Bolt

DAS

8

9-89

Location

Loc Qty

Loc Code

ST342

12

118518

12

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Shop Packet Print

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Picklist Print

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Parent Item: D4417-011

D4417-011

Parent Item Name: Q.R. Step Assembly (206L/407)

Start Date: 3/28/2016

Required Date: 3/29/2016

Start Qty: 1.00

Required Qty: 1.00

MS17984-C415

Purchased

No

120

Each

10.0000

2

2

MS17984-C415

PIN, QUICK RELEASE

Location

Loc Qty

Loc Code

ST315

10

mp128893

2

m129795

8

MS21043-4

Purchased

No

120

Each

1,128.000

4

4

MS21043-4

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

202

m132803

202

ST302

600

m134249

300

m134502

300

ST32

286

m133769

286

D4428-1

Manufactured

No

120

Each

11.0000

2

2

D4428-1

Bushing

Location

Loc Qty

Loc Code

ST098

11

112174

11

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Picklist Print

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Work Order ID: 141295

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Parent Item: D4417-011

D4417-011

Parent Item Name: Q.R. Step Assembly (206L/407)

Start Date: 3/28/2016

Required Date: 3/29/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

120

Each

1,577.000

8

8

NAS1149C0432R

WASHER

Location

Loc Qty

Loc Code

GA

642

m125807

428

m133790

214

ST266

935

m131467

67

m133577

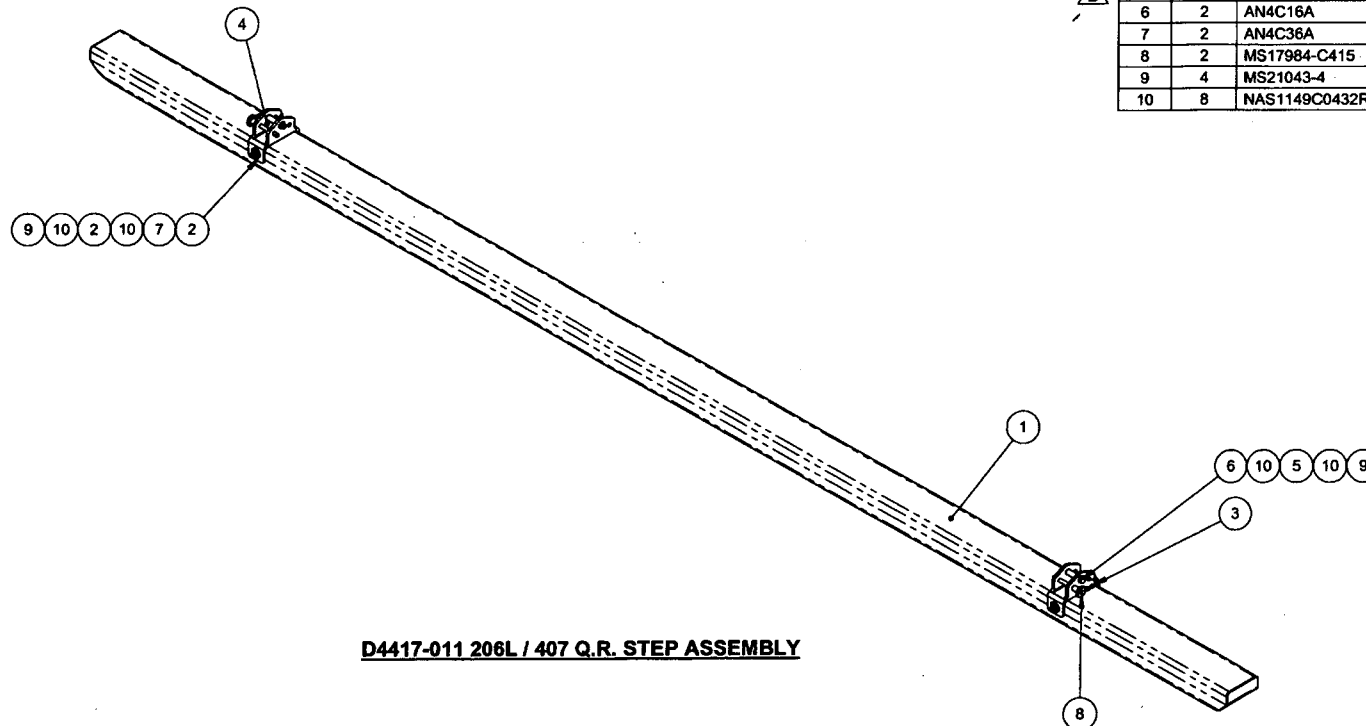
68

m134073

800

DAS
8
9-69

MAR 29 2016



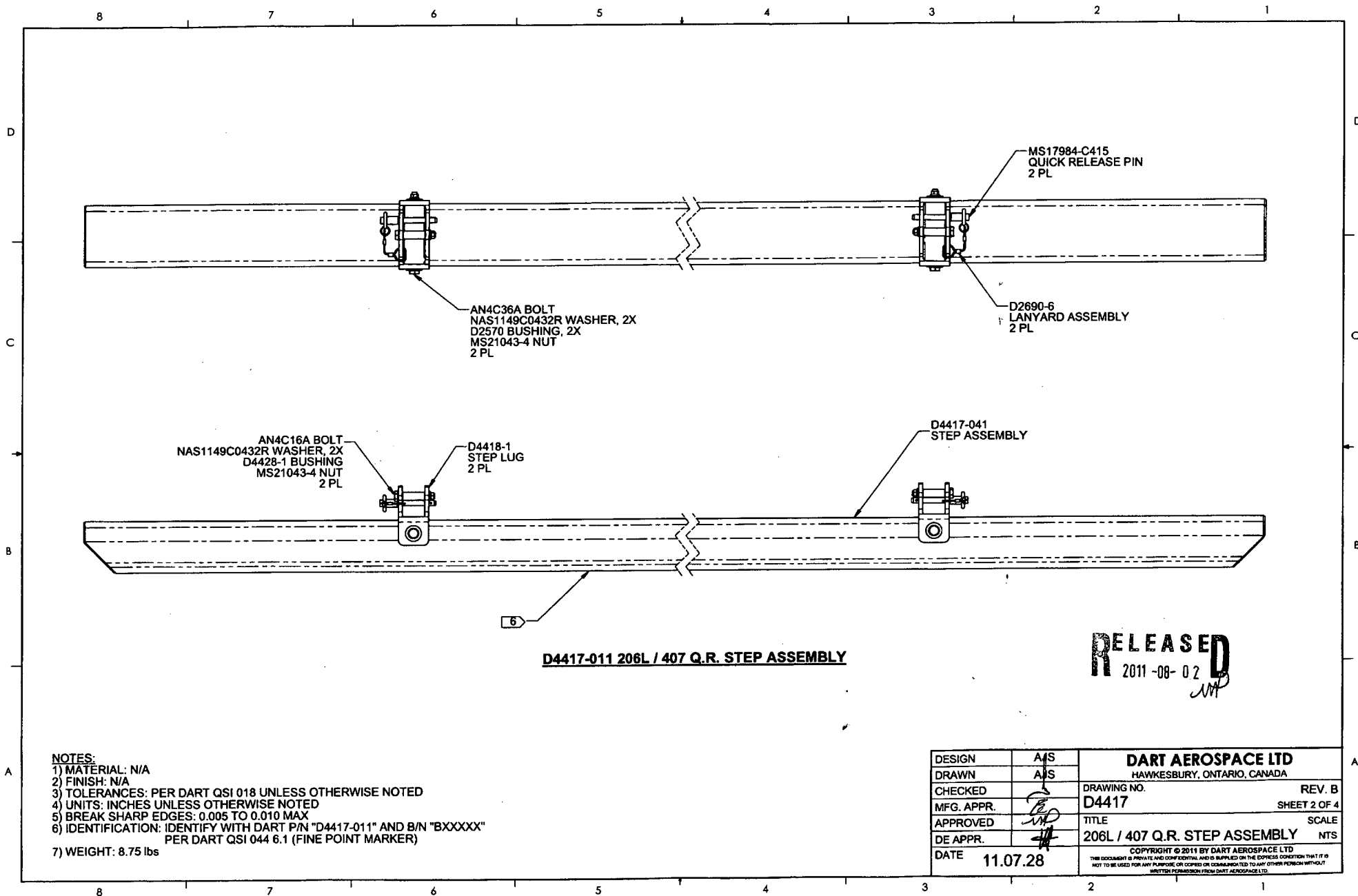
D4417-011 206L / 407 Q.R. STEP ASSEMBLY

ITEM	QTY	P/N	DESCRIPTION
	X	D4417-011	206L / 407 Q.R. STEP ASSEMBLY
1	1	D4417-041	STEP ASSEMBLY
2	4	D2570	BUSHING
3	2	D2690-6	LANYARD ASSEMBLY
4	2	D4418-1	STEP LUG
5	2	D4428-1	BUSHING
6	2	AN4C16A	BOLT
7	2	AN4C36A	BOLT
8	2	MS17984-C415	QUICK RELEASE PIN (BLBS-020)
9	4	MS21043-4	NUT
10	8	NAS1149C0432R	WASHER

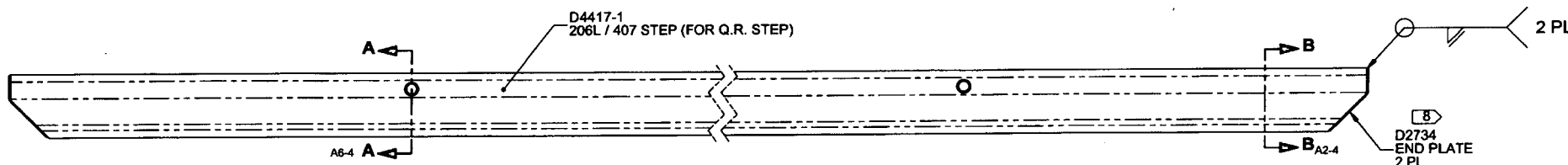
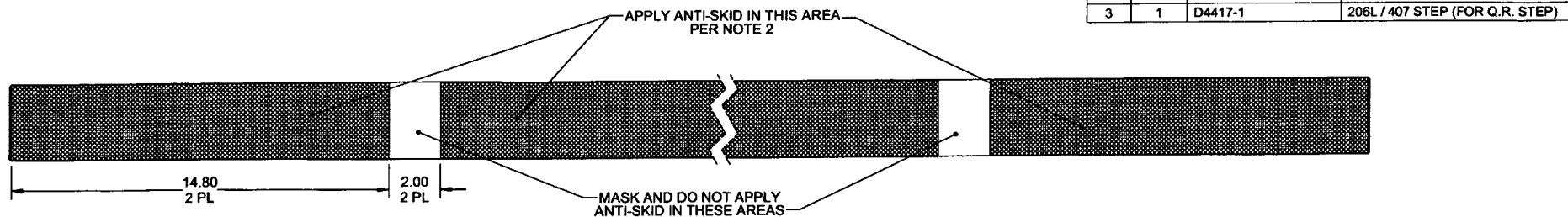
RELEASED
2011-08-02

B	REPLACED NAS43DD4-64 SPACER WITH ITEM 5, ITEM 3 WAS -S.	AJS	11.07.28
A	NEW ISSUE	AJS	11.07.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4417	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		206L / 407 Q.R. STEP ASSEMBLY	NTS
DATE	11.07.28	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

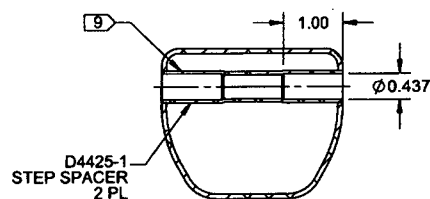
H 16-3-29
141295



ITEM	QTY	P/N	DESCRIPTION
	X	D4417-041	STEP ASSEMBLY
1	2	D2734	END PLATE
2	2	D4425-1	STEP SPACER
3	1	D4417-1	206L / 407 STEP (FOR Q.R. STEP)

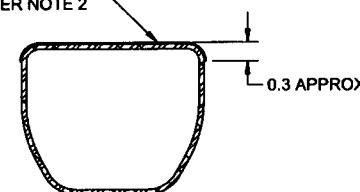


D4417-041 STEP ASSEMBLY



SECTION A-A C7-4
SCALE 2X

APPLY ANTI-SKID IN THIS AREA
PER NOTE 2



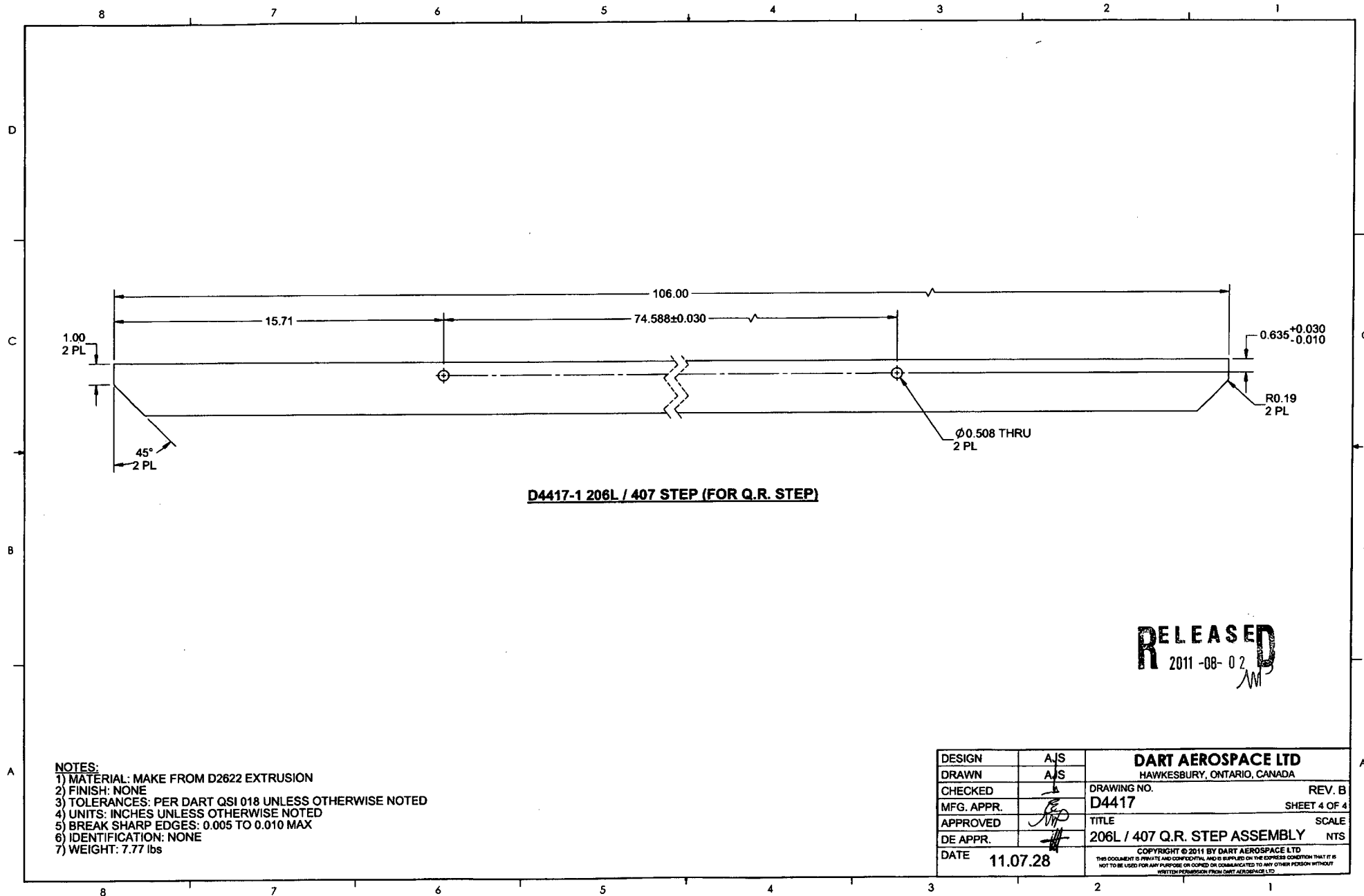
SECTION B-B C2-4
SCALE 2X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.00 lbs
- 8) APPLY ALODINE AFTER WELDING ON THE D2734 END CAPS AND PRIOR TO INSTALLATION OF D4425-1 STEP SPACERS.
- 9) SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO. D4417	REV. B
MFG. APPR.		SHEET 3 OF 4	
APPROVED		TITLE 206L / 407 Q.R. STEP ASSEMBLY	SCALE NTS
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2011-08-02



- NOTES:**
- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 7.77 lbs

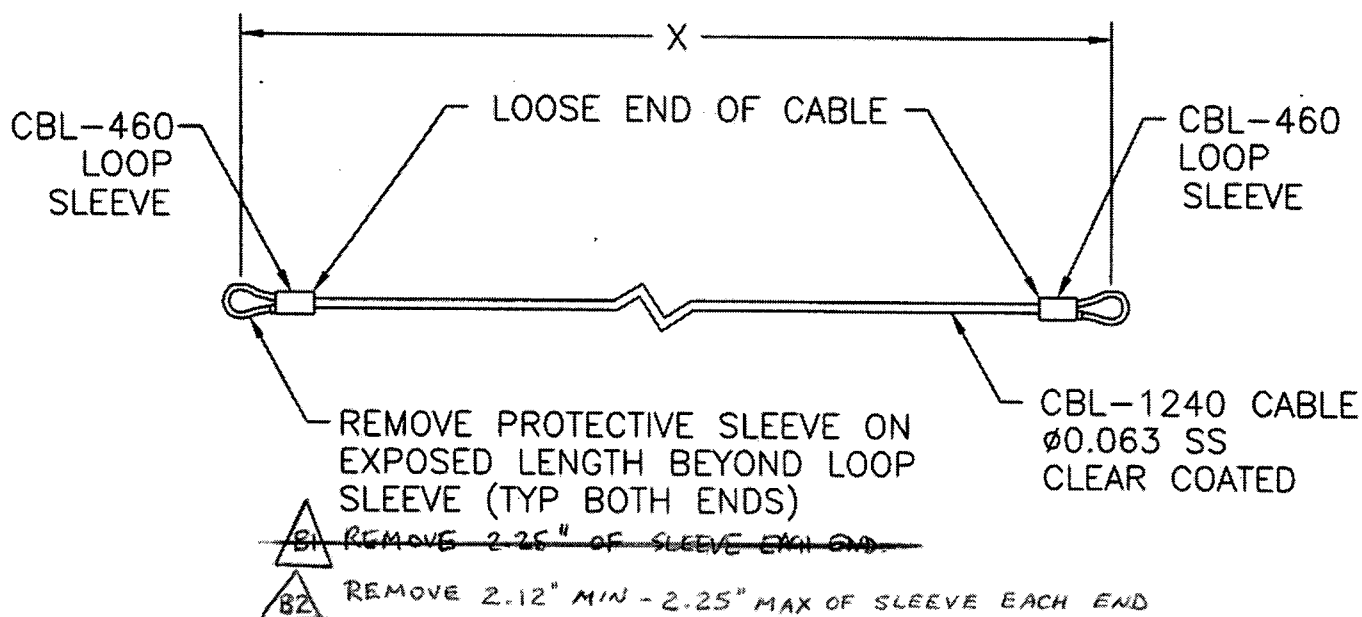
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4417	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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 2011-08-02



DESIGN <i>ME</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>ME</i>	APPROVED <i>BW</i>	DRAWING NO. D2690	REV. B SHEET 1 OF 1
DATE 97.10.02		TITLE LANYARD ASSEMBLY	SCALE NTS
A	97.07.03	NEW ISSUE	
B	97.10.02	REVISED NOTE FOR ADDITIONAL LENGTH	
B1	CP 01.08.20	ADD NOTE TO REMOVE 2.25" OF SLEEVE	
B2	CP 04.06.24	ADDED TOLERANCE	

RELEASED
971003 KE
TSR A374



D2690-X

X = LENGTH IN INCHES

NOTE: CUT CABLE 2.50* INCHES LONGER THAN 'X' LENGTH. FOLD ENDS TIGHT TO 'X' LENGTH AND CRIMP WITH SLEEVE AT END OF LOOSE END OF CABLE WITH CBL-705 CRIMPING TOOL.
*ADDITIONAL LENGTH MAY BE NECESSARY IN SOME APPLICATIONS. CUT AS REQUIRED.

NOTE: IN SOME CASES, END HAS TO BE CRIMPED AFTER ASSEMBLY WITH ATTACHING PARTS.

DEO's